

# Work Order ID 59528

June 7, 2010 9:55:27 AM



Page 1

Item ID: D407-547-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Console High Slope

Start Date: 6/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 6/09/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D206-547

Rev F

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4

2-Deburr

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

*Subtotal*

*JS 6/06/17 (2)*

*(+2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59528**

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Page 2

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Start Date: 6/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 6/09/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120



Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

1-Grind weld relief chamfer as per Dwg D206-547

2- clean rails with ultra bright aluminum cleaner before riveting

3- Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

*ES 06/17 (2)*

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*Susloc 117**(42)*

140



Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

1-Weld as per Dwg D206-547

A/R AL ROD Batch: *M 111385*

2-Grind weld as per dwg D206-547

*EL 10-5-21 (42)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 59528

June 7, 2010 9:55:27 AM



Page 3

Item ID: D407-547-047

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Setup Start



Revision ID:

Stop



Item Name: Console High Slope

Start Date: 6/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 6/09/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC9- Inspect visual per QSI004- Fusion Welds QC10	0.00				(x2)			
QC Quality Control	Memo 8/10/06/21	0.00							
	151. QCS inspect to current spec - 8/10/06/21					(x2)			
160 	Small Fab	0.00							
Small Fab Small Fab	Memo 1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3	0.00							
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo 8/10/06/22	0.00				(x2)			

8/10/06/22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 59528

June 7, 2010 9:55:28 AM



Page 4

Item ID: D407-547-047

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Setup Start



Revision ID:

Stop



Item Name: Console High Slope

Start Date: 6/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 6/09/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M112588

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:35  
320°  
2:05

2 BR 10-6-22

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 10 06 22 (2)

200

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

PP 59529

10-6-23 (2) d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 59528

June 7, 2010 9:55:28 AM



Page 5

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Item Name: Console High Slope

Start Date: 6/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 6/09/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/23 *[Signature]*

W10.06.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 7, 2010 9:55:25 AM

Page 1

Work Order ID: 59528

Parent Item: D407-547-047

Parent Item Name: Console High Slope





Comments: IPP Rev: 106-01-05 Removed Packing Kit JLM

Start Date: 6/07/10

Required Date: 6/09/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2024  Console Extrusion		Manufactured	No			120	f	1,183.000	3.42	72		6/10/06/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT06				1183					
					1			1183					
D2604-1  Console Side LH, 407 Console		Manufactured	No			120	Each	2.0000	1	2		6/10/06/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST178				2					
					51301			2					
D2604-2  Console Side RH, 407 Console		Manufactured	No			120	Each	2.0000	1	2		6/10/06/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST177				2					
					50248			2					
D2606  Console Bracket, 206/407 Console		Manufactured	No			120	Each	28.0000	1	2		6/10/06/17	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				28					
					53196			28					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 7, 2010 9:55:25 AM

Work Order ID: 59528

Parent Item: D407-547-047

Parent Item Name: Console High Slope




Comments: IPP Rev: 06-01-05 Removed Packing Kit JLM

Start Date: 6/07/10

Required Date: 6/09/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2608  Bracket, 407 Console		Manufactured	No			120	Each	11.0000	1	2		6/10/06/22	
<div> <div>Location</div> <div>ST020</div> <div>11</div> </div> <div> <div>Loc Qty</div> <div>35661</div> <div>11</div> </div> <div> <div>Loc Code</div> </div>													
MS20470AD3-3  Rivet, Universal Head		Purchased	No			120	Each	8,543.000	6	12		6/10/06/22	
<div> <div>Location</div> <div>ST319</div> <div>8543</div> </div> <div> <div>Loc Qty</div> <div>1065</div> <div>1435</div> </div> <div> <div>Loc Code</div> </div>													
MS20470AD3-4  Rivet, Universal Head		Purchased	No			120	Each	11,153.00	20	40		6/10/06/17	
<div> <div>Location</div> <div>ST319</div> <div>11153</div> </div> <div> <div>Loc Qty</div> <div>111477</div> <div>8332</div> </div> <div> <div>Loc Code</div> </div>													
<div> <div>Location</div> <div></div> <div>15541</div> </div> <div> <div>Loc Qty</div> <div></div> <div>2821</div> </div> <div> <div>Loc Code</div> </div>													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

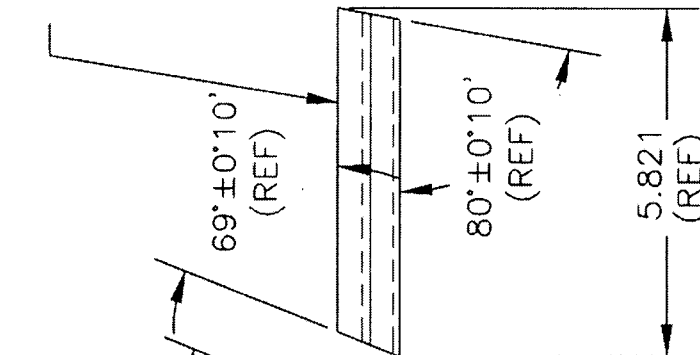


DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D2710	REV. B SHEET 1 OF 1
DATE 99.02.11		TITLE CONSOLE SIDE RAIL	SCALE 1:3
A	97.10.25	NEW ISSUE	
B	99.02.11	DELETE WELD, ADD TEMPL. (TSR A1020)	

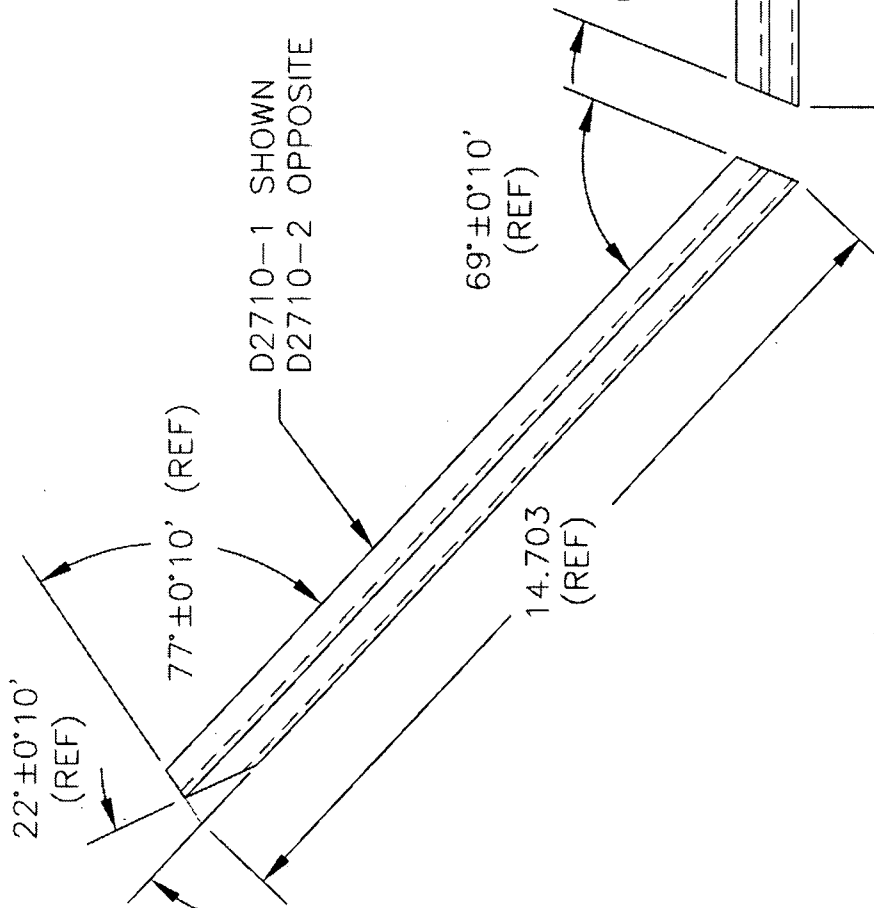
RELEASED  
99.03.05 KE



D2710-3 SHOWN  
D2710-4 OPPOSITE



D2710-1 SHOWN  
D2710-2 OPPOSITE



W/O 59528

MATERIAL: MAKE FROM D2024 EXTRUSION  
MAKE PER TEMPLATE: # DT8264  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>BW</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>KE</i>	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY SCALE NTS	
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED  
99.03.05 RE

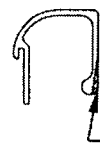
-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

59528



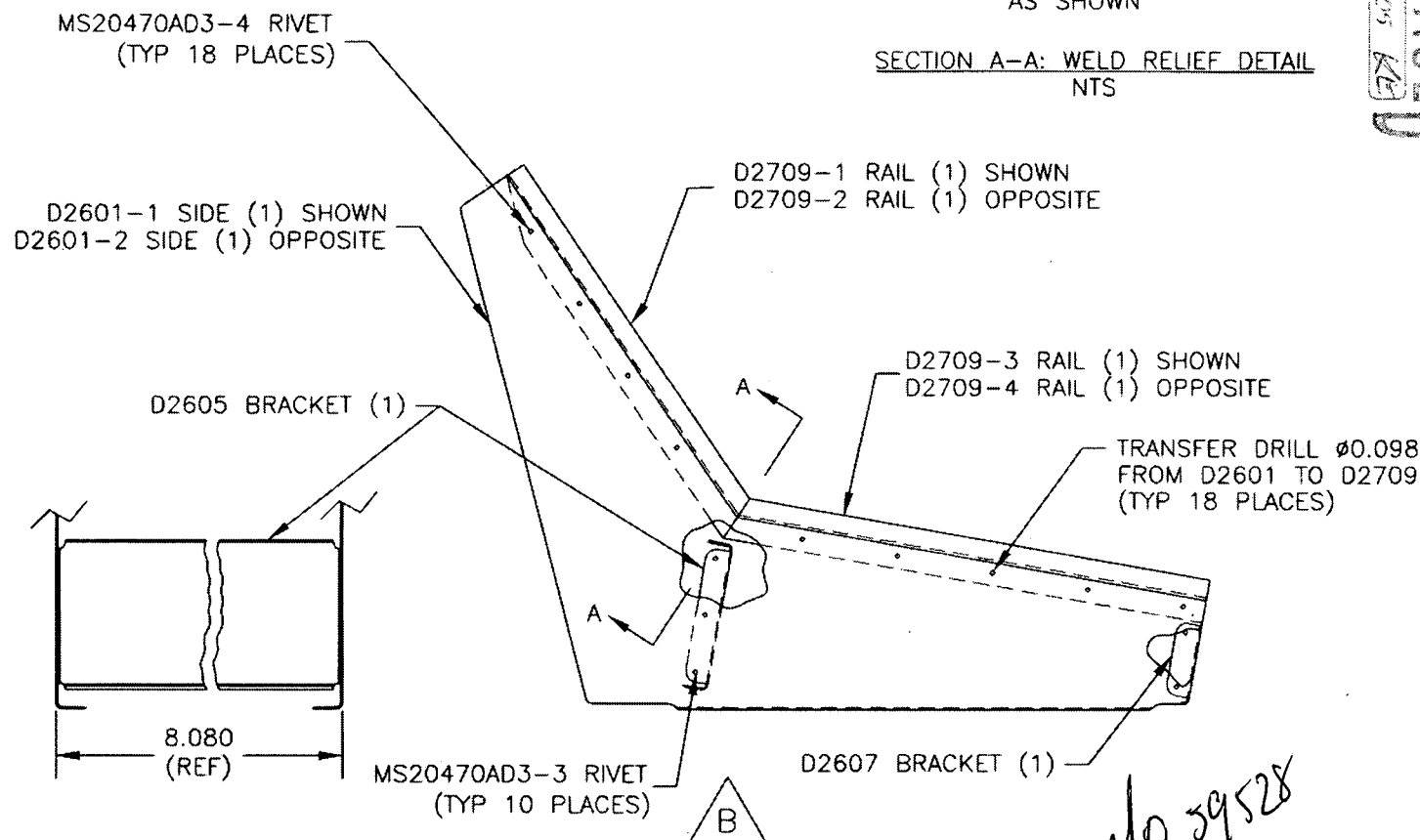
**DART**

RELEASED  
44.07.05 KE



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED	JP	APPROVED	KE	
DATE	99.02.11	TITLE	D206-547	REV. F
		CONSOLE ASSEMBLY		SHEET 2 OF 5
				SCALE 1:4

also 39528

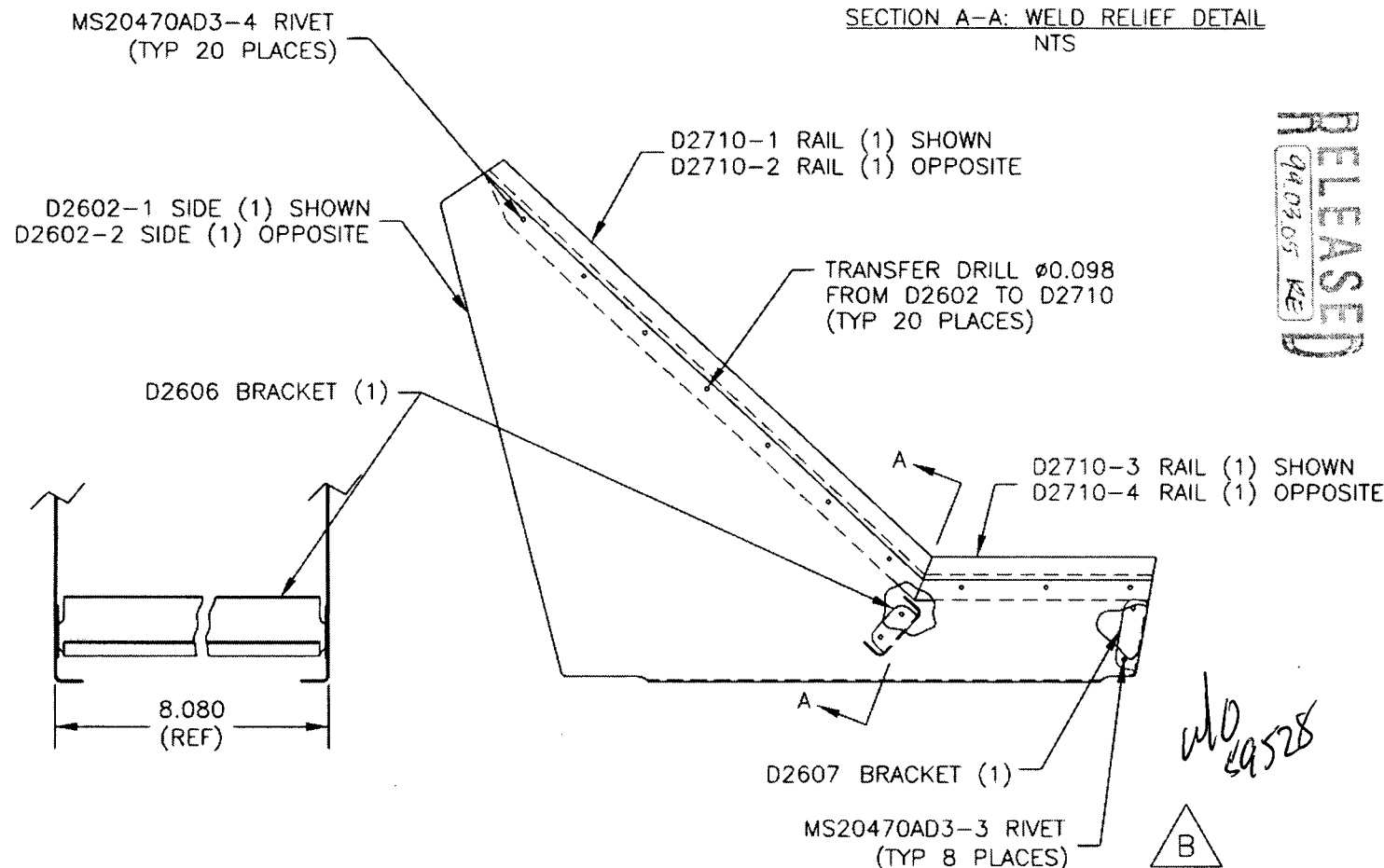
**DART**

RELEASED  
940305 KE



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

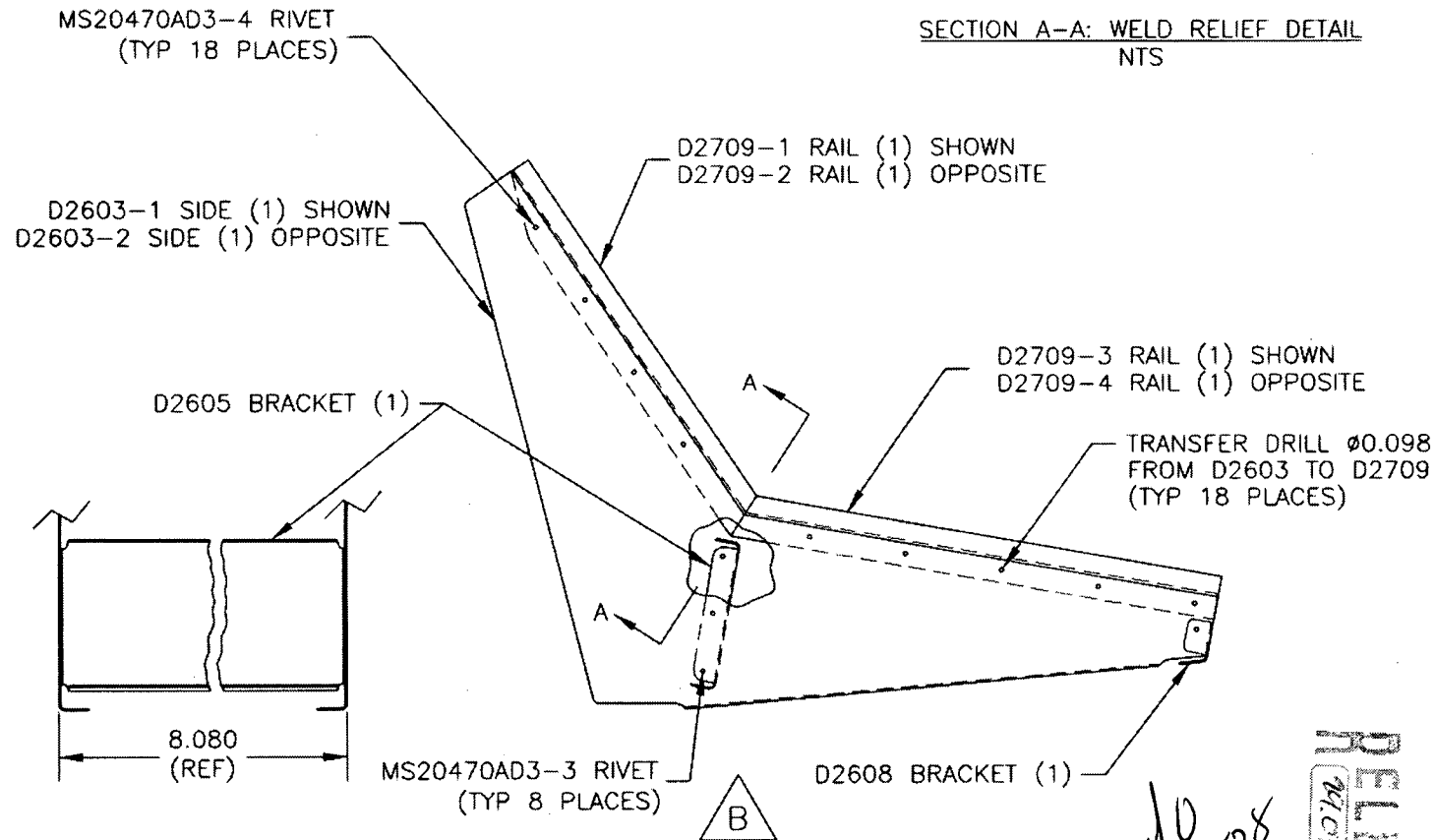
DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	UP	APPROVED	KE	
DATE	99.02.11	DRAWING NO.	D206-547	REV. F
		TITLE	CONSOLE ASSEMBLY	SHEET 3 OF 5
		SCALE	1:4	

**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN BW	DRAWN BY KF	DART AEROSPACE LTD HANESBURY, ONTARIO, CANADA	REV. F
CHECKED JF	APPROVED KE	DRAWING NO. D206-547	SHEET 4 OF 5
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	

RELEASED  
99.03.05 KE

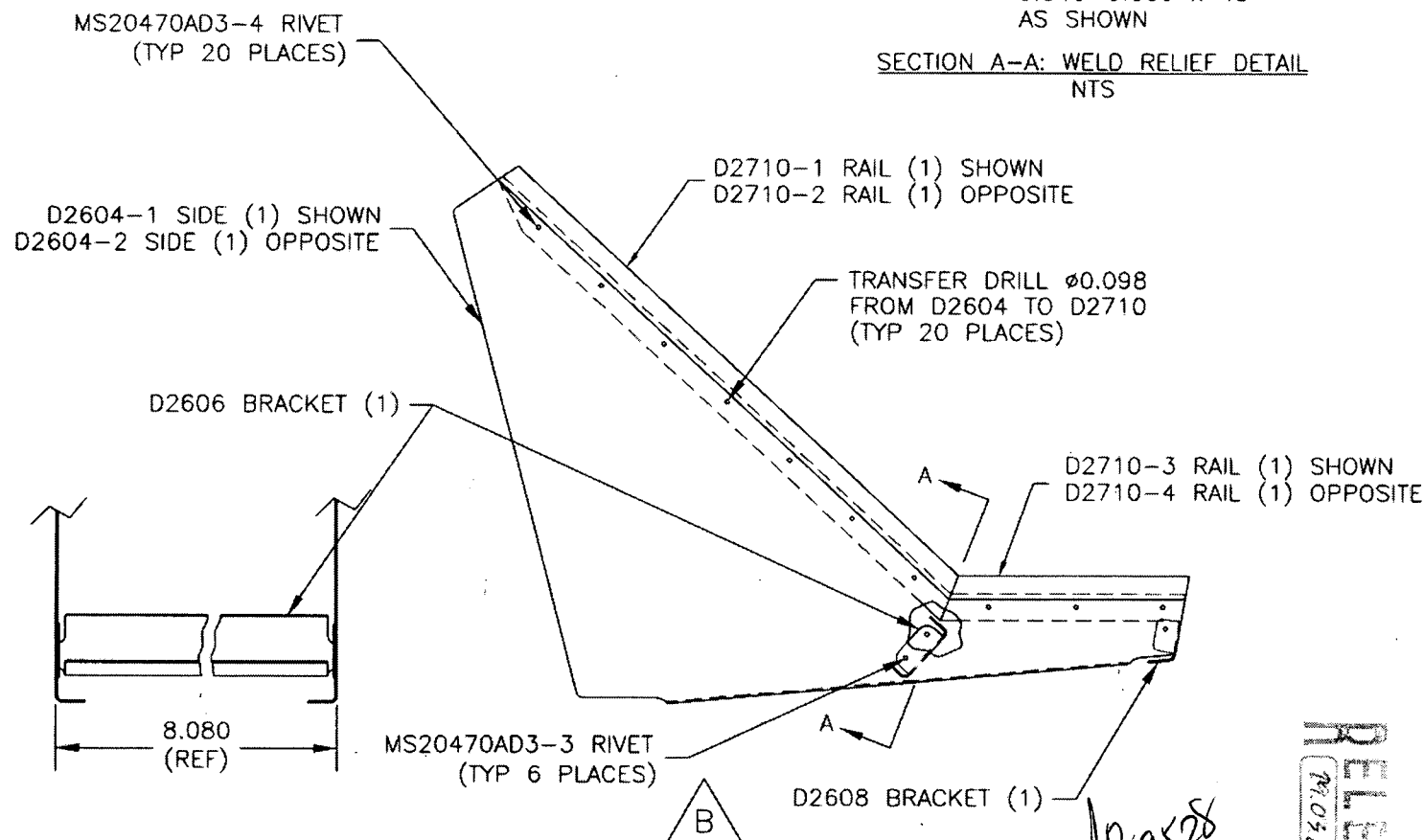
WLO  
59528

**DART**



GRIND RELIEF  
CHAMFER FOR WELD  
0.040-0.050 x 45°  
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL  
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
M0405 KE

DESIGN Bw	DRAWN BY KE	DART AEROSPACE LTD HAMESBURY, ONTARIO, CANADA
CHECKED JP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 5 OF 5
		SCALE 1:4